



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D5445-042
Job Sheet 183683



Part No: D5445-042

Job Qty: 2 ea

Part Name: Longitudinal Beam Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/24/18

Job Tracking No: **SIOP**

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D5445 REV C SHEETS 2,5 IPP REV:A 17.01.10 NEW ISSUE DD VERF:JLM IPP REV:B 17.11.15 REVISE AS PER INTUITIVE INSTRUCTION DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		10/12/18	0.00	0.00	Start Up Skidtubes-1		<i>M.C.G.</i>
100	CNC Bend Skidtubes	2 pcs		10/12/18	0.00	2.00	CNC Bend Skidtube		<i>M.C.G.</i>
110	QC	2 pcs		10/12/18	0.00	0.00	QC2		<i>38</i>
120	Mill Conv	2 pcs		10/12/18	0.00	2.00	Mill Conv 1		<i>38</i>
130	QC	2 pcs		10/12/18	0.00	0.00	QC2		<i>18/11/12</i>
140	QC	2 pcs		10/12/18	0.00	0.00	QC8		<i>18/11/12</i>
150	HandFinish	2 pcs		10/12/18	0.00	1.00	HandFinish1		<i>D.R. 18/11/13</i>
160	QC	2 pcs		10/12/18	0.00	0.00	QC7		<i>38</i>
170	Small Fab	2 pcs		10/12/18	0.00	2.00	Small Fab		<i>38</i>
180	QC	2 pcs		10/12/18	0.00	0.00	QC5		<i>38</i>
184	Skidtubes	2 pcs		10/12/18	0.00	1.00	Skidtubes-2		<i>38</i>
186	QC	2 pcs		10/12/18	0.00	0.00	QC5		<i>38</i>
190	Powdercoat	2 pcs		10/12/18	0.00	1.00	Powdercoat1		<i>38</i>
200	QC	2 pcs		10/12/18	0.00	0.00	QC3		<i>38</i>
210	HandFinish	2 pcs		10/12/18	0.00	1.00	HandFinish4		<i>38</i>
220	QC	2 pcs		10/12/18	0.00	0.00	QC5		<i>38</i>
230	Packaging	2 pcs		10/12/18	0.00	0.00			<i>38</i>
240	QC21-SA	2 Ea		10/12/18	0.00	0.00	QC21		<i>38</i>

Part Op 100 - BEND/CUT AS PER DWG

Descriptions: 120 - -MILL/DRILL AS PER DWG. -insure proper orientation -DEBURR

170 - INSTALL NUT PLATES AS PER DWG

184 - 1- Pick (4) D4720-1 space for each beams and chemical convert them. 2- Swage x-bolt spacers as per dwg. Trim off access material as required. 3- After swaging, ream x-spacer hole if necessary to finish size. 4- Touch up alodine after swaging. 5-INSTALL END CAP

190 - ***MASK NUT PLATE HOLES*** START TIME: **8:55** OVEN TEMPERATURE: **300°** FINISH TIME:

210 - SEAL END CAPS WITH SIKAFLEX AS PER NOTE 11

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6TR1.5X1.0W125	6061-T6 Rect Tube 1.5 X 1.0 X .125W	12 ft (6 ea)	90-Start up Operation	<i>M137953</i>
CR2672-3-(03)	Cherry Rivet	16 Ea (8 ea)	170-Small Fab	<i>FM137878.81</i>
MS21059-4	Nut Plate	6 Ea (3 ea)	170-Small Fab	<i>5057521</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date: _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

MS21061L4
D4720-1
D5445-043
MS24694-S3

Nutplate
Spacer
End Cap Assembly
Screw

2 Ea (1 ea) 170-Small Fab
8 Ea (4 ea) 184-Skiddtubes
4 Ea (2 ea) 184-Skiddtubes
8 Ea (4 ea) 184-Skiddtubes

S065257
~~S014595~~
F158775
S016894

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6TR1.5X1.0W125	12	36	0
170-Small Fab	CR2672-3-(03)	16	71	0
	MS21059-4	6	43	0
	MS21061L4	2	49	0
184-Skiddtubes	D4720-1	8	312	0
	D5445-043	4	20	0
	MS24694-S3	8	115	0

Part Specifications

Specifications could not be found.

Plex 9/24/18 2:58 PM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S118181



Part: D5445-042
Job No. 133693
Serial No/Batch: S118181
Revision: C
Inspector:
Exp Date:
Instructions: Various STC's

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/15/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	183683
Description: Longitudinal Beam Assy RH		Part Number:	DS445-042
Inspection Dwg: DS445	Rev:	Page 1 of 1	

INSPECTION SHEET

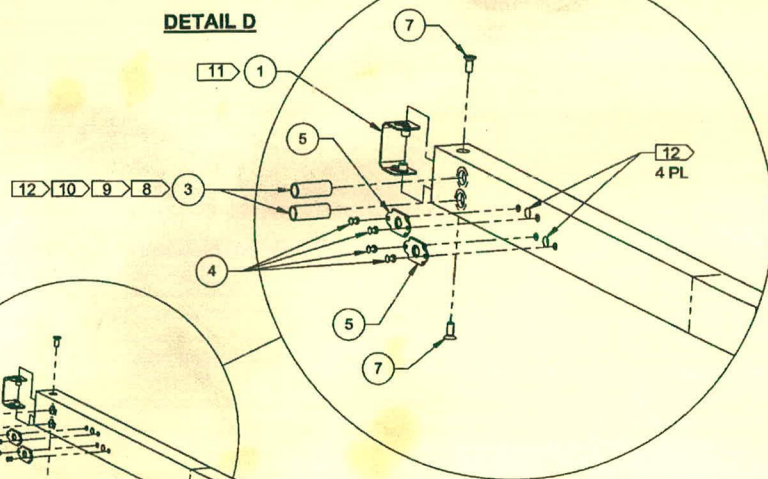
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0,60	± 0,020	0,600	/		Vernier J/Vos	
0,177 Ø	± 0,005 - 0,001	0,178	/		"	
0,320 x 100° Ø	± 0,010	0,325 x 100°	/		"	
62,8	± 0,12	62,81	/		Tape	
1,00 REF	± 0,030	0,996	/		Vernier J/Vos	
54,63	"	54,625	/		Tape	
1,50 REF	"	1,497	/		Vernier J/Vos	
1,50	"	1,500	/		"	
1,000	± 0,010	1,000	/		"	
4,97	± 0,030	4,971	/		"	
0,500	± 0,010	0,500	/		"	
0,50	± 0,030	"	/		"	
1,200	± 0,010	1,200	/		"	
0,85	± 0,030	0,850	/		"	
0,300	± 0,010	0,300	/		"	
0,600	"	0,600	/		"	
0,375 Ø	+0,006 - 0,001	0,376	/		"	
0,266 Ø	"	0,267	/		"	
0,098 Ø	+0,004 - 0,001	0,098	/		"	
0,179 x 100° Ø	± 0,010	0,180 x 100°	/		"	
0,500	"	0,502	/		"	
0,312	"	0,312	/		"	
0,500	"	0,501	/		"	
1,000	"	1,000	/		"	

Measured by:	Checked by:	QC Inspector:
Date: 11/11/12	Date:	Date:

Engineering Approval: (If necessary)	Date:
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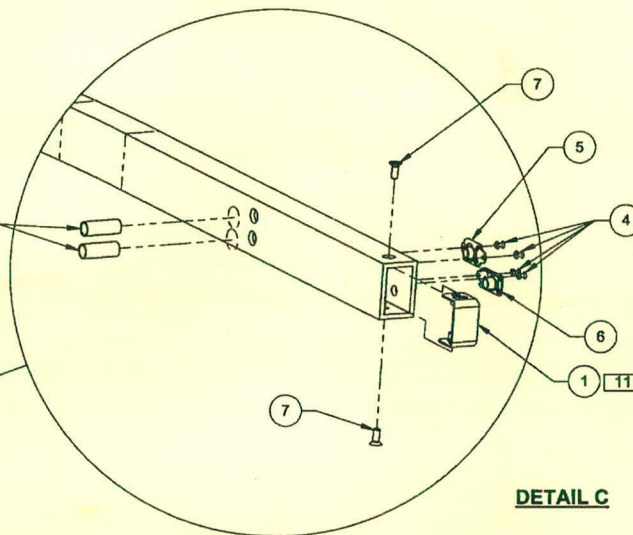
Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DETAIL D



12 10 9 8 3

DETAIL C



ITEM	QTY	P/N	DESCRIPTION
	X	D5445-042	LONGITUDINAL BEAM ASSEMBLY, RH
1	2	D5445-043	END CAP ASSEMBLY
2	1	D5445-2	LONGITUDINAL BEAM, RH
3	4	D5445-5	SPACER
4	8	CR2672-3-(03)	RIVET CHERRY, CSK
5	3	MS21059-4	NUT PLATE
6	1	MS21061L4	NUT PLATE
7	4	MS24694-S3	SCREW, CSK 100"
8	A/R	SIKAFLEX-241/-291	SEALANT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.50 lbs
- 8) SWAGE TO $\phi 0.313$ THRU PER QSI 002 4.2
- 9) TRIM/GRIND FLUSH PER QSI 002
- 10) REAM THRU SPACERS USING $\phi 0.313$ REAMER
- 11) SEAL END CAPS WITH SIKAFLEX-241/-291
- 12) MASK HOLES PRIOR TO POWDER COAT

D5445-042 LONGITUDINAL BEAM ASSEMBLY, RH

RELEASED
2017-03-22

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WK	DRAWING NO. D5445	REV. C
MFG. APPR.	JLM	SHEET 2 OF 7	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LONGITUDINAL BEAM ASSY	NTS
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